

Date: Friday, 01/08/2008 1:05:38 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BUSHING		
Job Number	: 40930			Part Number	: D32093		
Estimate Number	: 11148			Drawing Number	: D3209 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 01/08/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /			Due Date	: 08/08/2008		
Previous Run	: 35633			Qty:	20 Um: Each		
Written By	: <u>J. J. 08-08-01</u>						
Checked & Approved By	:						
Comment	: Est A 04.04.14 New issue KJ/RF						
Additional Product							
Job Number:							
Seq. #:	Machine Or Operation:	Description :					
1.0	M303R0500	303 Round Bar 0.500"					
							
Comment: Qty.: 0.0350 f(s)/Unit Total: 0.6993 f(s) Delrin Round Bar .50 black Material: AISI 303 SS Ø0.50" (M303R0.500) Identify for D3209-3 Batch: <u>M108626</u> mm= 08/08/02							
2.0	HARDINGE	HARDINGE CNC LATHE SMALL					
							
Comment: HARDINGE CNC LATHE SMALL Turn D3209-3 bushing as per Folio FA354 and Dwg D3209 mm= 08/08/02							
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE					
							
Comment: INSPECT PARTS AS THEY COME OFF MACHINE mm= 08/08/02							
4.0	QC8	SECOND CHECK					
							
Comment: SECOND CHECK Anf 08/08/03							
5.0	PACKAGING 1	PACKAGING RESOURCE #1					
							
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>S777</u> P 08/08/05							

Date: Friday, 01/08/2008 1:05:38 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 40930

Part Number: D32093

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Docket#

MF 08-08-06

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART AEROSPACE LTD	Work Order:	40930
Description: Bushing	Part Number:	D3209-3
Inspection Dwg: D3209 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>mjt</i>	Audited by:	<i>Amf</i>	Prototype Approval:	N/A
Date:	08/08/02	Date:	08/08/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.07	New Issue	KJ/JLM	
B	07.01.16	Tolerance for Ø0.500 revised	JLM/EC	

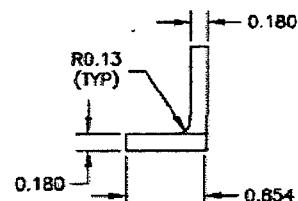
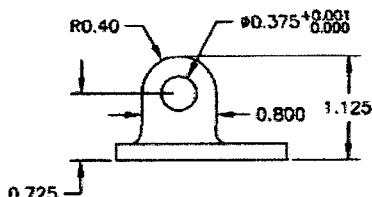
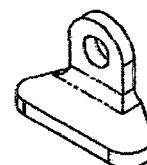
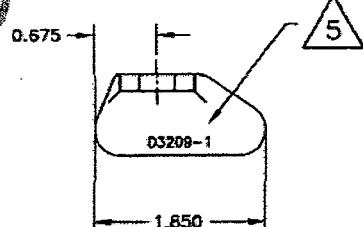


COPY 1 OF 5
2005

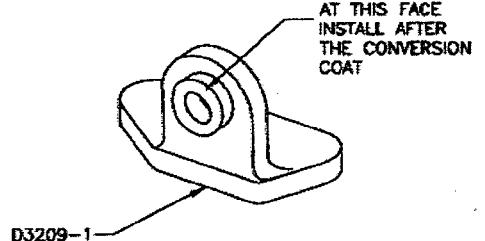
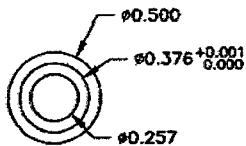
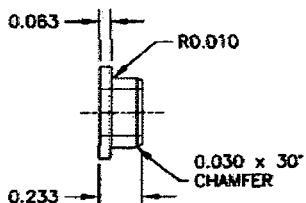
DESIGN <i>TF</i>	DRAWN BY <i>TF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TF</i>	APPROVED <i>TF</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 *TF*

w/o 40930



2 D3209-1 BRACKET



3 D3209-3 BUSHING
SCALE 1:2

4 D3209-041 ASSEMBLY

D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.